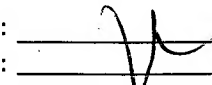


Date: Wednesday, 16/07/2008 3:31:37 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT FACING SEAT ASS'Y RH
Job Number :	40001		
Estimate Number :	13314		
P.O. Number :		Part Number :	D412769044
This Issue :	16/07/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D412-769-2 REVB
First Issue :	1/1	Project Number :	N/A
Previous Run :	40001	Drawing Revision :	B
Written By :		Material :	
Checked & Approved By :		Due Date :	31/07/2008
Comment :	Est rev A 08.05-12 new issue DD verified by:ec Est Rev:B 08-07-17 revB as per dwg DD verified by:ec		
Qty:	1	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0	D3782045-	Back Leg Assembly
-----	-----------	-------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Back Leg Assembly
 batch: B 40306

SB

3.0	D3782041	Front Inboard Leg Assembly
-----	----------	----------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Front Inboard Leg Assembly
 batch: B 40303

SB

4.0	D3782044	Front Outboard Leg Assembly, RH
-----	----------	---------------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Front Outboard Leg Assembly, RH
 batch: B 40305

SB

5.0	D3783041	Lateral Brace Assembly
-----	----------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Lateral Brace Assembly
 batch: B 40307

SB 08/08/14 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-769-044 PAR #: No Fault Category: FAB - Improved NCR: Yes No DQA: LA Date: 08.08.21
 QA: N/C Closed: SD Date: 29/08/21

NCR: 40001		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/9/13	11.0	Dubbing assembly it was found that the D3766-21 was Drill all. R.C. Drilled by to manually and missed at inspection.	MSKMP	Scrap all D3766-21 stock (LQ by (XZ)) and replace on be a different w/o.	SAY 08/08/13	SKS 08/08/14	MSKMP	C 06/06/13

NOTE: Date & initial all entries

Date: Wednesday, 16/07/2008 3:31:37 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASSY RH

Job Number: 40001

Part Number: D412769044

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0

D3783043

Longitudinal Brace Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Longitudinal Brace Assembly
batch: B 40308

SB

7.0

D3783045

Angle Brace Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Angle Brace Assembly
batch: B 40309

SB

8.0

D3784041

Seat Support Assembly, Center



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Seat Support Assembly, Center
batch: B 40659

SB

9.0

D3784043

Seat Support Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Seat Support Assembly, LH
batch: B 40660

SB

10.0

D3784044

Seat Support Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Seat Support Assembly, RH
batch: B 40661

SB

11.0

D37662

Front Rail, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Front Rail
batch: B 40709 B 41218

SB

12.0

D37663

Rear Rail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Rear Rail
batch: B 40710

SB 08/08/14

(1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 16/07/2008 3:31:37 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40001

Part Number: D412769044

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

13.0	D37671	Upper Rail
------	--------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Upper Rail

batch: B4674

SB

14.0	D37921	Seat Belt Eye Bolt
------	--------	--------------------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Seat Belt Eye Bolt

batch: B40999

SB

15.0	AN415A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M108077

SB

16.0	AN45 13A	EYE BOLT
------	----------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

EYE BOLT

batch: M107938

SB

17.0	AN510A	Bolt
------	--------	------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch: M107534

SB

18.0	AN513A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M108167

SB

PTD

19.0	AN960JD10	Washer
------	-----------	--------



Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)

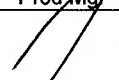

Washer

batch: M108558

(or NAS1149D0363J) batch: _____

SB 08/08/14 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng Prod Mgr	Approval QC Inspector
08/03/14	18	add AWS-13A Bolt M 108 147 7 total. update dwg.	SS	08/03/14	5	 08-08-14	 08-08-14

Part No: D412-169-044 PAR #: _____ Fault Category: _____ NCR: ☒ Yes ☐ No DQA: h Date: 08.08.21
 QA: N/C Closed: _____ Date: _____

NCR: <u>40001</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/08/14	18.	Need Qty of 7 AUS-13A. Missing 5 on the ASS'y	08/08/14	update dwg to correct the Qty. See PAR 08-030 to update the Qty.	08/08/14	08/08/14	08/08/14	08/08/14
				PAR cancelled 08.08.21				

NOTE: Date & initial all entries

Date: Wednesday, 16/07/2008 3:31:37 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40001

Part Number: D412769044

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

20.0	AN960JD416	Washer
------	------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M108166

(or NAS1149D0463J) batch: _____

SB

21.0	AN960JD516	Washer
------	------------	--------



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

batch: M108246

(or NAS1149D0568J) batch: _____

SB

22.0	AN52510R24	Screw
------	------------	-------



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Screw

batch: M108270

23.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Nut

batch: M107665

SB

24.0	MS21042L4	Nut
------	-----------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M108480

SB

25.0	MS21042L5	Nut
------	-----------	-----



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: M108421

SB 08/08/14 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 16/07/2008 3:31:37 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40001

Part Number: D412769044

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble as per dwg D412-769-2

SB 08/08/14 (1)

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

28.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- mask D3782-041 and D3782-043 front legs and D3787-1 foot as per dwg D412-769-041

2- Powder coat remainig of assembly grey as per dwg D412-769-2

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:00
320
1:30

M-L 08/08/14

(1X)

29.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-14 (X)

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

31.0

D37751

Guard



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Guard

batch: M40658

SB 08/08/15 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 16/07/2008 3:31:37 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40001

Part Number: D412769044

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

32.0	D37741	Seat Bottom, LH/RH
------	--------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Seat Bottom, LH
batch: B40587

SB 08/08/15 1

33.0	D37743	Seat Back, LH/RH
------	--------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Seat Bottom, LH
batch: B40588

SB 08/08/15 1

34.0	AN525 10R22	Screw
------	-------------	-------



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)
Screw
batch: M107936

SB 08/08/15 1

35.0	AN96JD10L	Washer
------	-----------	--------



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)
Washer
batch: M105793
(or NAS1149D0332J) batch: _____

SB 08/08/15 1

36.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s)
Nut
batch: M107665

SB 08/08/15 1

37.0	AN35A	Bolt
------	-------	------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Bolt
batch: M100188

SB 08/08/15 1

38.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
------	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
1- install remaining parts as per dwg D412-769-2

SB 08/01/15 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 16/07/2008 3:31:37 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40001

Part Number: D412769044

Job Number:



Seq. #:

Machine Or Operation:

Description :

39.0

QC5

INSPECT WORK TO CURRENT STEP



08.08.15

Comment: INSPECT WORK TO CURRENT STEP

40.0

PACKAGING 1

PACKAGING RESOURCE #1



(1x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP 40573

8/8/15

SV

41.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/1998

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



LC 08.08.15

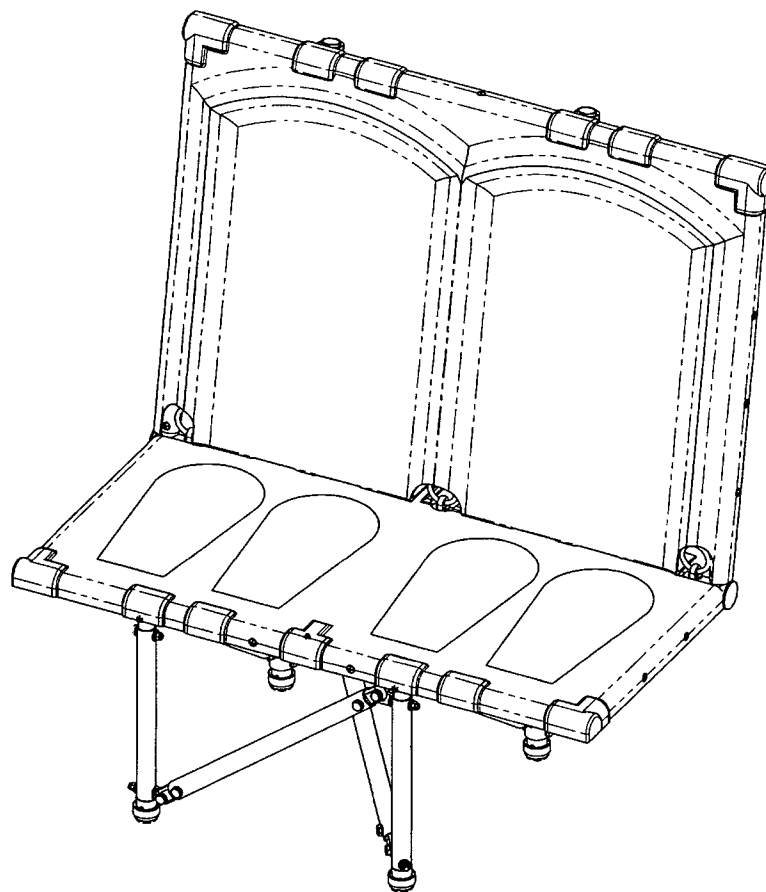
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D412-769-044 AFT FACING SEAT, RH

RELEASE
08.07.10 M/P

B	NEW HARDWARE	HS	08.06.25
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D412-769-2 REV. B SHEET 1 OF 7 TITLE AFT FACING SEAT ASSY, RH SCALE NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED, COPIED, OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	
DRAWN	HS		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	08.06.25		

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 WORK ORDER
 NO. 40001

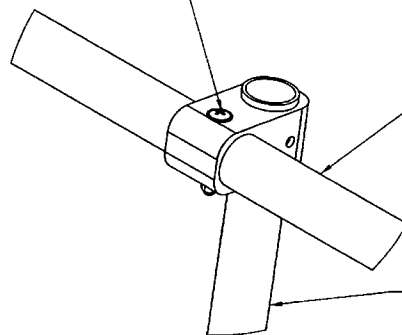
SEAT, RH
RELEASED
08-07-10

1) MATERIAL: N/A
FINISH: POWDER COAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3 PRIOR TO
INSTALLATION OF SEAT BOTTOM/BACK (D3774-1,-3). MASK FRONT LEGS PRIOR TO POWDER COAT
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: IDENTIFY WITH D2729-1 RED DECAL ATTACHED TO BACK LEG ASSEMBLY (D3782-045)
WEIGHT: 20.0 lbs
ITEM 15 (D2724-1) SEAT BOTTOM) AND ITEM 16 (D3774-3 SEAT BACK) REMOVED FOR CLARITY

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D412-769-2 TITLE AFT FACING SEAT ASSY, RH COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRINTED AT THE REQUEST OF THE CAPTAIN. CAPTAIN'S SIGNATURE THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIES OR COMMUNICATED TO ANY OTHER PERSON, WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	REV. B
DRAWN	HS		SHEET 2 OF 7
CHECKED	<i>HS</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
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DATE 08.06.25			

INSTALLATION TOLERANCE UNITS: INCH
BREAK SHAFT IDENTIFICATION
TWO LIGHT ENGINEERING
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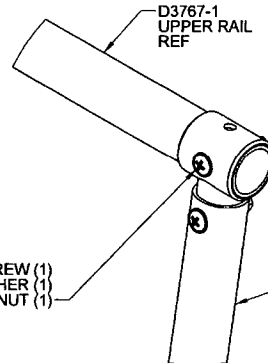
AN525-10R24 SCREW (1)
NAS1149D0363J WASHER (1)
MS21042L3 NUT (1)



D3767-1
UPPER RAIL
REF

D3782-045
BACK LEG ASSY
REF

DETAIL A_{D2-2}
UPPER RAIL TO BACK LEG ATTACHMENT
2 PL



D3767-1
UPPER RAIL
REF

AN525-10R24 SCREW (1)
NAS1149D0363J WASHER (1)
MS21042L3 NUT (1)

D3784-044
SEAT SUPPORT ASSY, RH
REF

DETAIL B_{C1-2}
SEAT SUPPORT END ATTACHMENT (TYP)
5 PL

RELEASED
08-07-10

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D3782-045
BACK LEG ASSY
REF

AN45-13A EYE BOLT (1)
NAS1149D0568J WASHER (1)
MS21042L5 NUT (1)

D3766-3
REAR RAIL
REF

AN525-10R24 SCREW (1)
NAS1149D0363J WASHER (1)
MS21042L3 NUT (1)

DETAIL C C2-2
REAR RAIL TO BACK LEG ATTACHMENT

AN525-10R24 SCREW (1)
NAS1149D0363J WASHER (1)
MS21042L3 NUT (1)

D3766-3
REAR RAIL
REF

D3782-045
BACK LEG ASSY
REF

DETAIL E C2-2
REAR RAIL TO BACK LEG ATTACHMENT

D3784-041
SEAT SUPPORT ASSY, CENTER
REF

DETAIL D C1-2
SEAT SUPPORT ASSY, CENTER ATTACHMENT

D3766-3
REAR RAIL
REF

D3792-1 SEAT BELT EYE BOLT (1)
NAS1149D0568J WASHER (2)
MS21042L5 NUT (1)

D3792-1 SEAT BELT EYE BOLT (1)
NAS1149D0568J WASHER (2)
MS21042L5 NUT (1)

RELEASED
07-10-12

D3766-3
REAR RAIL
REF

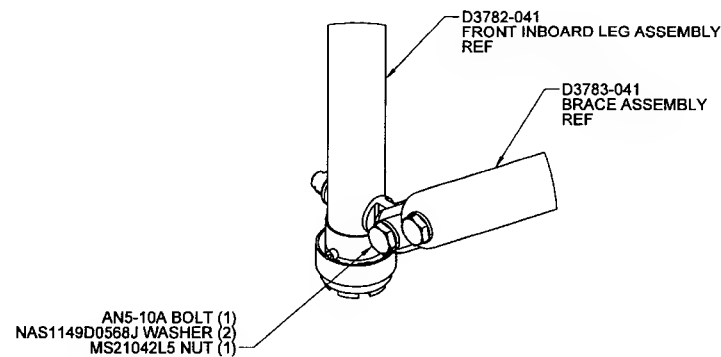
D3775-1
GUARD
REF

D3784-044
SEAT SUPPORT ASSY, RH
REF

DETAIL F B1-2
SEAT SUPPORT ATTACHMENT
2 PL

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D412-769-2	SHEET 4 OF 7
APPROVED		TITLE	SCALE
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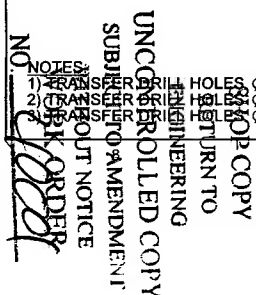


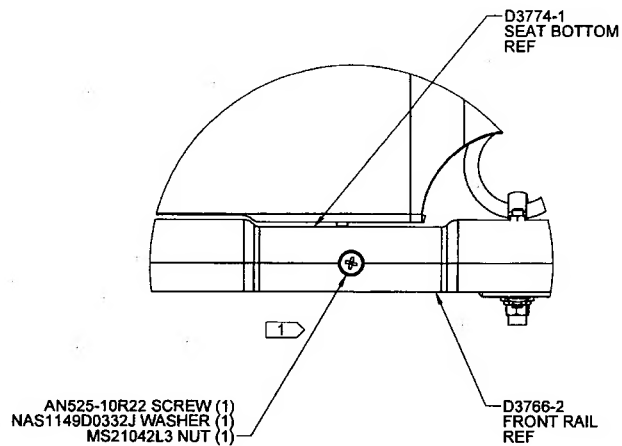
DETAIL G_{B3-2}
BRACE ATTACHMENT
6 PL

RELEASED
06.07.10

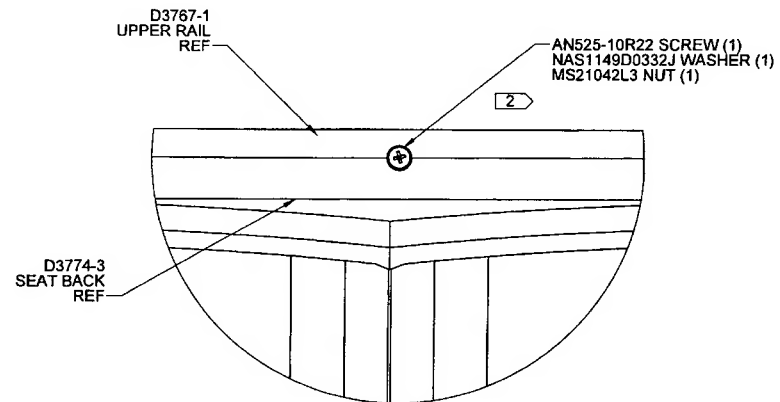
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DRAWN	HS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D412-769-2	REV. B SHEET 5 OF 7
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	AFT FACING SEAT ASSY, RH	
DE APPR.	<i>[Signature]</i>	NTS	
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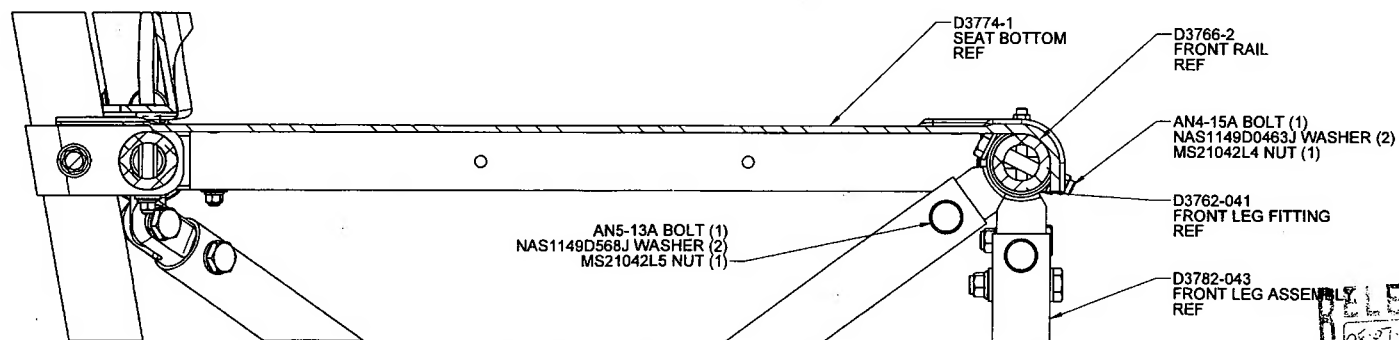






DETAIL L B7-6
SEAT BOTTOM ATTACH - FRONT DETAIL



DETAIL M D7-6
SEAT BACK ATTACH - TOP DETAIL



SECTION N-N B7-6
FRONT LEG AND LONGITUDINAL ANGLE ATTACHMENT

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D412-769-2	SHEET 7 OF 7
APPROVED		TITLE	SCALE
DE APPR.		AFT FACING SEAT ASSY, RH	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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- 1) TRANSFER FROM D3774-1 TO D3766-2 0.201 FROM FRONT RAIL (D3766-2) TO SEAT BOTTOM (D3774-1) - 2 PL
2) TRANSFER FROM D3767-1 TO D3774-3 0.201 FROM UPPER RAIL (D3767-1) TO SEAT BACK (D3774-3) - 1 PL

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